

Work Order ID 64345

Friday, December 03, 2010 3:11:52 PM

Page 1

Item ID: D4111-3

Accept

Revision ID:

Item Name: Sill Fitting

Start Date: 12/2/2010 Start Qty: 12.00

Required Date: 12/15/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10/12/3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4111

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK TO 2.345" LONG

0.00

cm 10/12/10

12

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA965

DWG REV: B

FOLIO REV: AA

0.00

cm 10/12/16

12

(2)

(PTC)

2-DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4111-3 PAR #: _____ Fault Category: Failure NCR: Yes No DQA: 1 Date: 10/12/17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 10/12/20






NCR: <u>64345</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/12/16</u>	<u>110</u>	<u>1 part scrap. prog not updated 1 part scrap report of the vice.</u> <u>RC program / COA.</u>	<u>[Signature]</u>	<u>scrap, destroy and replace Qty 1</u> <u>Batch # 115555</u> <u>* Program has been corrected</u>	<u>[Signature]</u> <u>10/12/16</u>	<u>H.A</u> <u>10/12/17</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/12/17</u>



NOTE: Date & initial all entries




Work Order ID 64345

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Item ID: D4111-3 Accept  Setup Start 
Revision ID:
Item Name: Sill Fitting Stop 
Start Date: 12/2/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 12/15/2010 Req'd Qty: 12.00  Customer:
Reference:






Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>and 10/12/16</i>		<u>12</u>	<u>0</u>		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>J. A 10/12/17</i>		<u>12</u>	<u>0</u>		
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>138</u> Memo	0.00 0.00							<i>12/10/17 (12)</i>


Work Order ID 64345


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Item ID: D4111-3 Accept  Setup Start 
Revision ID:
Item Name: Sill Fitting Stop 
Start Date: 12/2/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 12/15/2010 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/12/2010 

U 10-12-17

Picklist Print

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Page 1

Work Order ID: 64345



Parent Item: D4111-3



Parent Item Name: Sill Fitting

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP Rev:B
10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	12.8290	0.21	2.652632			



303 BAR 1" X 1"



Location

Loc Qty

Loc Code

MAT

11.6

→ 115555

11.6

MAT53

1.22896

113719

1.22896

2.653

mk 10/2/10

DART AEROSPACE LTD		Work Order: 64345
Description: SILL FITTING		Part Number: D4111-3
Inspection Dwg: D4111	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

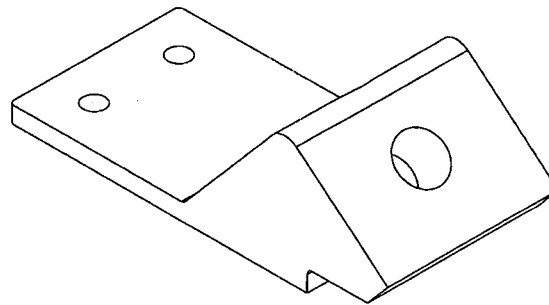
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.128	+ .005 - .001	Ø.128	✓		Vern	ML-7
.25	± .030	.242	—		"	"
.25	± .030	.252	✓		"	"
.500	± .010	.499	✓		"	"
1.00	± .030	.988	✓		"	"
1.250	± .010	1.251	✓		"	"
2.22	± .030	2.220	✓		"	"
.50	± .030	.495	✓		"	"
Ø.313	+ .006 - .001	Ø.317	✓		"	?
Ø.640	± .010	Ø.637	✓		"	"
.100	± .010	.102	✓		"	"
1.030	± .030	1.032	✓		"	"
.894	± .010	.895	✓		"	"
.300	± .010	.304	✓		"	"
.80	± .030	.800	✓		"	"
.74	± .030	.740	✓		"	"
.18	± .030	.188	✓		"	"
40°	± 1/2°	40°	✓		Comb-square	ML-CBB
.125	± .010	.123	—		Vern	ML-7
.35	± .030	.342	✓		"	"
1.75	± .030	1.758	✓		"	"
.400	± .010	.400	✓		"	"
.50	± .030	.495	✓		"	"

Measured by: <i>amk</i>	Audited by: <i>A.A</i>	Prototype Approval:	N/A
Date: 10/12/16	Date: 10/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 04345

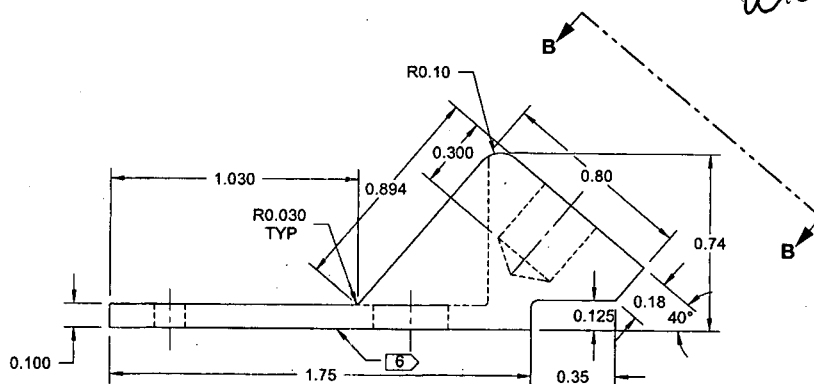
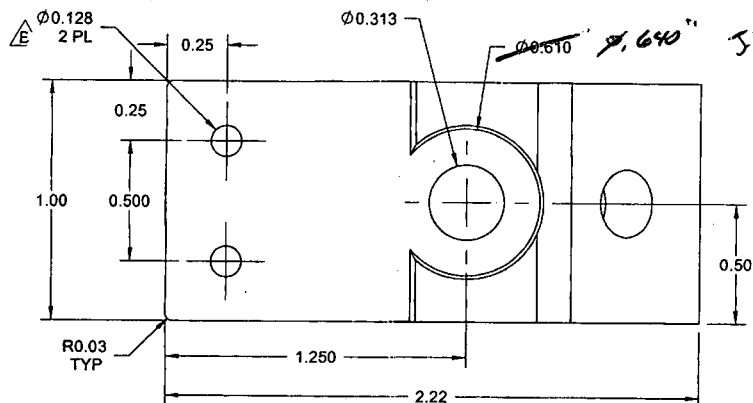
2/10-10-3



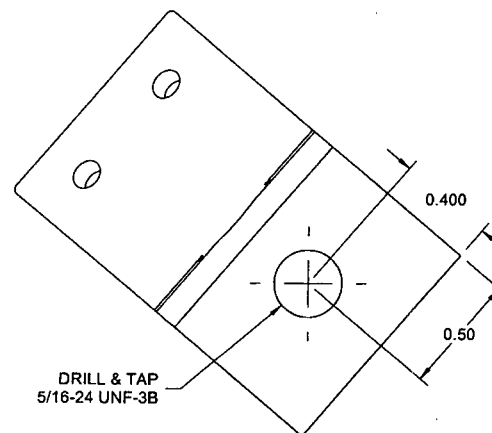
D4111-3 SILL FITTING

RELEASED
 2010-11-30
mm

B	D4111-1 DELETED (REPLACED BY D4111-3 ON INSTL) D4111-3: Ø0.128 2 PL WAS 4 PL (D8-3) TO IMPROVE INSTL.		JPH	10.11.01
A	NEW ISSUE		JPH	10.07.20
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4111 TITLE SILL FITTING SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	JPH			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>	REV. B SHEET 1 OF 2		
DATE	10.11.01			



D4111-3 SILL FITTING



VIEW B-B

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4111-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4111	REV. B
MFG. APPR.	JPH	TITLE SILL FITTING	SHEET 2 OF 2
APPROVED	JPH	SCALE NTS	
DE APPR.	JPH		
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